

Date: Monday, 5/1/2006 4:00:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 26887		
Estimate Number	: 11025		
P.O. Number	: N/A	Part Number	: D27497
This Issue	: 5/1/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2749 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B
	Type: MACHINED PARTS	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 5/15/2006
Checked & Approved By	: 06.05.02	Qty:	15 Um: Each
Comment	: Est: C 00.05.19 Added inspection level 8, removed P/O for powder coating EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"
-----	--------------------	-------------------------



Comment: Qty.: 0.9844 f(s)/Unit Total: 14.7656 f(s)  
 6061-T6 Bar .75" x .75"  
 Material: 3/4" x 3/4" bar 6061-T6

M100742(

Batch: M17869 (6 pcs)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut blank: 11.25" long

SD 06.05.07

15

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio D2749-7

SD 06.05.07

15

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 06.05.07

15

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.E 06/05/08 15

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Q Date: 26/05/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 5/1/2006 4:00:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 26887

Part Number: D27497

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

SD 06.05.07

15

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:05:09

15

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-09 15

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-09

15

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SC 06 05 09

18

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57151

06/05/10

15

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/11 15

Job Completion



U 0605-11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

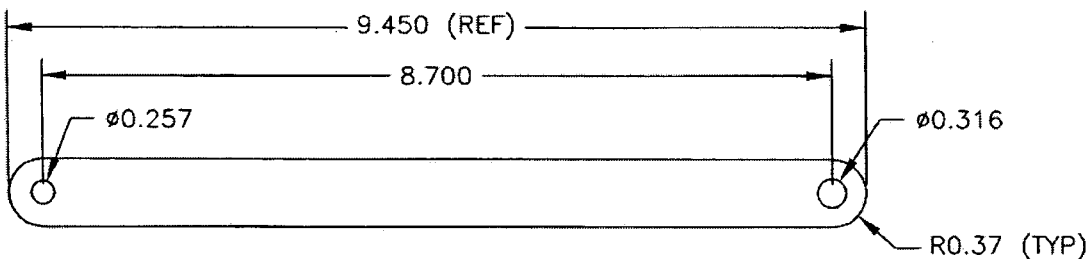
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

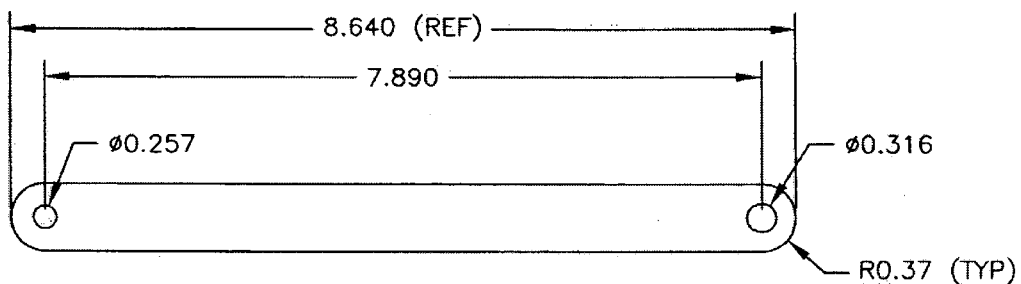


RELEASED  
99.10.12 ke

DESIGN	AE	DRAWN BY	AE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	AE	APPROVED	AE	
DATE	99.10.08	DRAWING NO.	D2749	REV. B
		TITLE	STRUT	SHEET 1 OF 2
				SCALE 1:2
A		99.09.24	NEW ISSUE	
B		99.10.08	REMOVED LIGHTENING HOLES	



2749-1 STRUT



2749-3 STRUT

MATERIAL: 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8) 0.75 X 0.75 BAR  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3

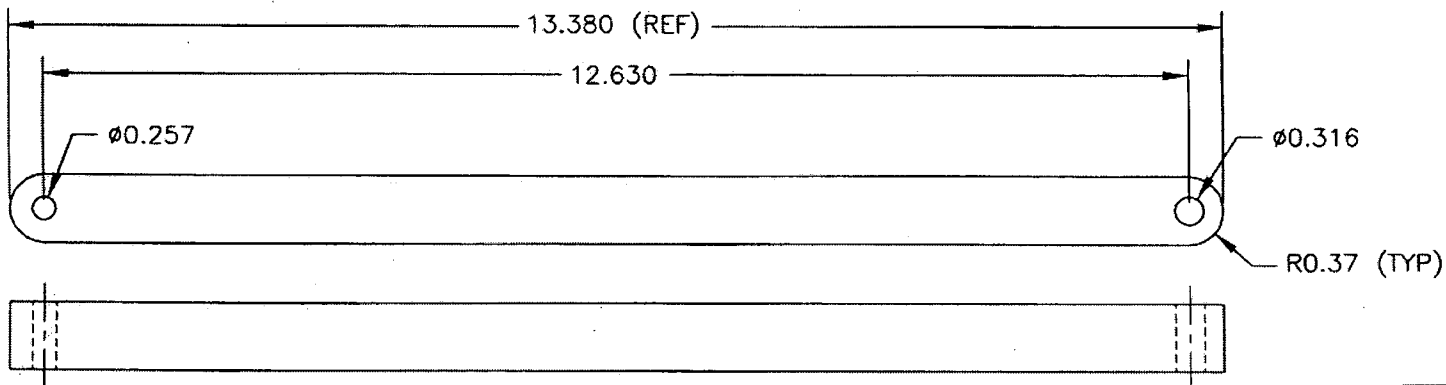
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WITHOUT NOTICE

WORK ORDER  
NO. 26887

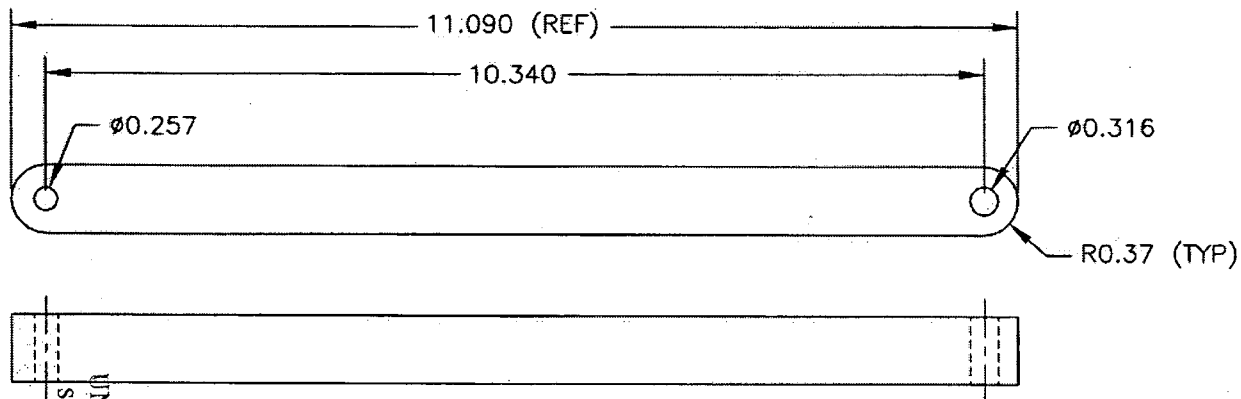


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2749	REV. B
DATE 99.10.08	TITLE STRUT	SHEET 2 OF 2	SCALE 1:2

RELEASED  
99.10.12 KE



2749-5 STRUT



2749-7 STRUT

MATERIAL: 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8) 0.75 X 0.75 BAR  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3

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WORK ORDER  
NO. 26887

